

**IN THE CLAIMS:**

Please amend the claims as follows:

Claims 1-16   **(Cancelled)**

17.     **(Currently amended)**     A machine programming and control system,  
comprising:

        a machine;

        a computer based controller coupled to said machine and being adapted to  
edit, debug, and generate a continuous multi-block flowchart representing a program and to  
control the operations of the machine in accordance with said flowchart; and

        a display connected to said computer based controller and being adapted to  
aid in editing and generating the flowchart, the display being adapted to display a plurality of  
blocks associated with the flowchart, wherein a first set of the ~~[[block]]~~ blocks is displayed  
in a first color and at least one other block is displayed in a second color, the first set of  
blocks being dependent from the at least one other block.

18.     **(Previously presented)**     The system, as set forth in claim 17, wherein  
the at least one other block corresponds to an active block during a runtime execution.

Claim 19.     **(Cancelled)**

20.     **(Previously presented)**     The system, as set forth in claim 17, wherein  
the at least one other block corresponds to an active block during a debugging process.

Claim 21     **(Cancelled)**

22.     **(Previously presented)**     The system, as set forth in claim 17, wherein the at least one other block corresponds to blocks that have been modified during an editing process.

23.     **(Previously presented)**     The system, as set forth in claim 18, wherein a third set of blocks are displayed in a third color.

24.     **(Previously presented)**     The system, as set forth in claim 23, wherein the third set of blocks are dependent upon the active block.

25.     **(Previously presented)**     The system, as set forth in claim 23, wherein the third set of blocks are associated with the active block.

26.     **(Previously presented)**     The system, as set forth in claim 17, wherein the at least one other block is associated with a break point.

27.     **(Previously presented)**     The system, as set forth in claim 17, wherein the display is adapted to form a debugging window for displaying the blocks and having a tool bar for controlling program flow.

28.     **(Previously presented)**     The system, as set forth in claim 27, wherein the tool bar includes a toggle labels button and the computer based controller responds to actuation of the button for switching between default labels and alternate labels displayed for the blocks.

29.     **(Previously presented)**         The system, as set forth in claim 27, wherein the tool bar includes a Select Active Block button and the computer based controller responds to actuation of the button for displaying a currently active one of the blocks.

30.     **(Previously presented)**         The system, as set forth in claim 17, wherein the computer based controller includes means for adding a break point associated with a flowchart block and wherein the computer based controller being adapted to stop at the break point during the debugging mode.

31.     **(Currently amended)**         A method of machine programming and control, comprising the steps of:

          editing and generating a continuous multi-block flow chart via a computer based controller, the flow chart representing a program for controlling the operations of a machine connected to the computer based controller;

          operating the machine in accordance with the flowchart; and,

          displaying a plurality of blocks associated with the flowchart on a display, wherein a first set of the blocks are displayed in a first color and a second set of the blocks are displayed in a second color, the second set of the blocks being dependent upon the first set of the blocks.

32.     **(Currently amended)**         The method, as set forth in claim 31, wherein the ~~at least one other block~~ first set of blocks corresponds to an active block during a runtime execution.

Claim 33     **(Cancelled)**

34.     **(Currently amended)**           The method, as set forth in claim 31, wherein the ~~at least one other block~~ first set of blocks corresponds to an active block during a debugging process.

Claim 35     **(Cancelled)**

36.     **(Currently amended)**           The method, as set forth in claim 31, wherein the ~~at least one other block~~ first set of blocks corresponds to blocks that have been modified during an editing process.

37.     **(Previously presented)**       The method, as set forth in claim 32, wherein a third set of blocks are displayed in a third color.

38.     **(Previously presented)**       The method, as set forth in claim 37, wherein the third set of blocks are dependent upon the active block.

39.     **(Previously presented)**       The method, as set forth in claim 37, wherein the third set of blocks are associated with the active block.